

PRELIMINARY ISSUE

11.10.04

Page 1

Work Order ID 74053

Wednesday, September 21, 2011 9:04:32 AM



Item ID: D3806-1

Accept



Setup Start



Revision ID:

Item Name: Bar

Stop



Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3806

~~PB1~~~~PB2~~~~10-28~~~~B~~~~11.10.04~~~~ECW11-640~~

100



Mill Conv

Memo

Conventional Milling Machine

1-mill as per Dwg D3806

2-Deburr if necessary

0.00

0.00

*B.A. 11/09/28**20 0*

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

*-inspector to PB1
Dwg only
8/21/28 (20)*

150



Packaging

Packaging

Identify as per dwg & Stock Location: *W/A*

Memo

0.00

0.00

*Q 11-9-29**X20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74053



Page 2

Wednesday, September 21, 2011 9:04:32 AM

Item ID: D3806-1

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Revision ID:

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Item Name: Bar

Start Date: 9/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/14

ME 11-09-29

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

ECN 11-640

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, September 21, 2011 9:04:29 AM

Page 1

Work Order ID: 74053

Parent Item: D3806-1

Parent Item Name: Bar



Start Date: 9/21/2011

Required Date: 9/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec
 IPP Rev:B 08-09-23 redesign DD verified by:EC
 IPP Rev:C 08-09-30 redesign DD verified by:EC
 D 11.06.03 re-design EC verified by:DD
 IPP rev

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased	No			100	f	205.3147	3.66	77.05263			
304 BAR .250 x .500													

Location	Loc Qty	Loc Code
MAT006	109.3	
116148	78	
117842	31.3	
MAT050	96.0147	
117176	96.0147	

M119050 X 85'

ent 11/09/28

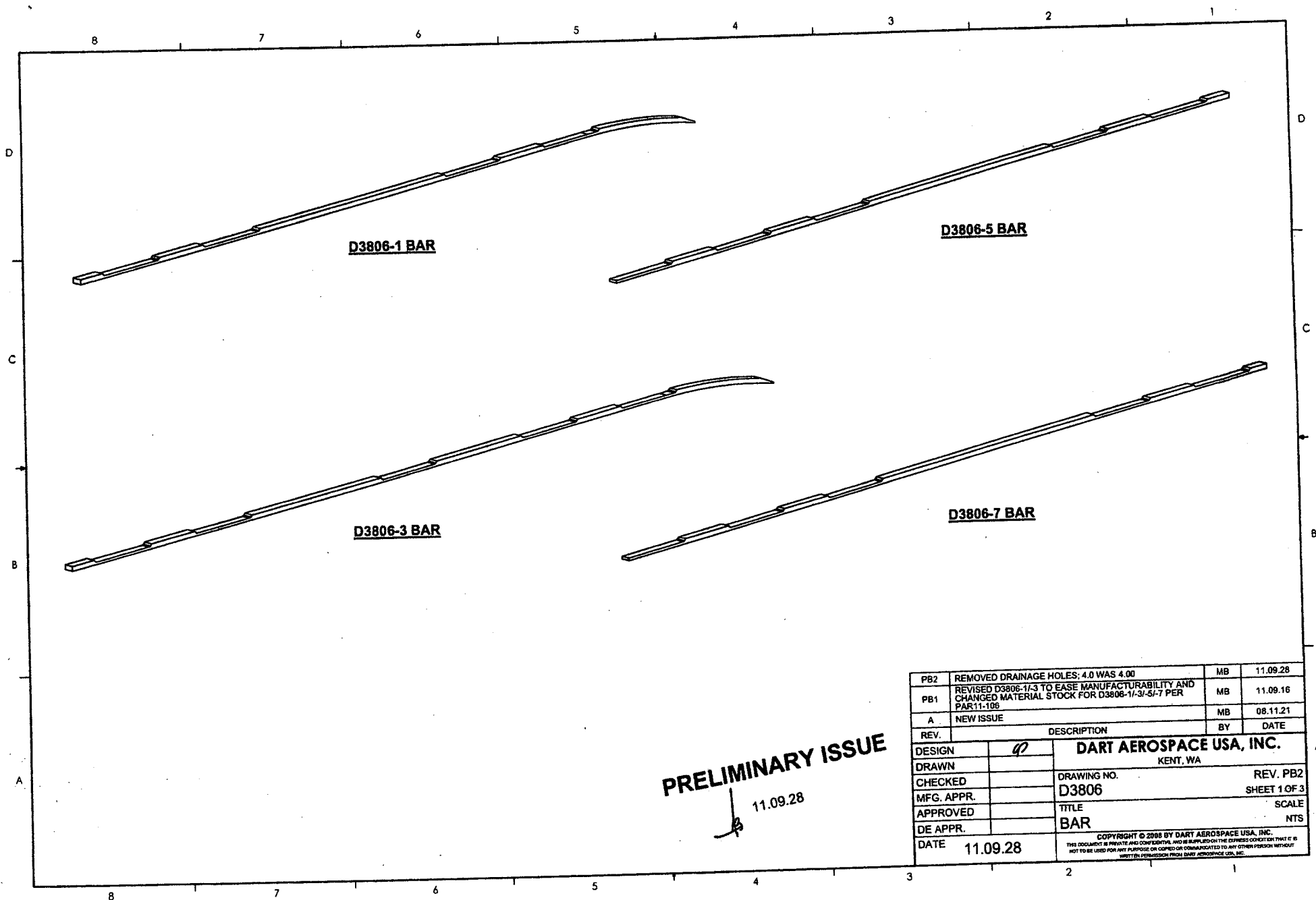
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRELIMINARY ISSUE

11.09.28

PB2	REMOVED DRAINAGE HOLES; 4.0 WAS 4.00	MB	11.09.28
PB1	REVISED D3806-1/-3 TO EASE MANUFACTURABILITY AND CHANGED MATERIAL STOCK FOR D3806-1/-3/-5/-7 PER PAR11-106	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	qp	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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8

7

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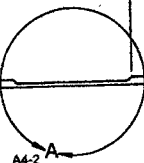
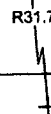
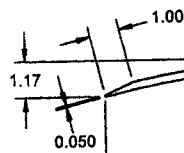
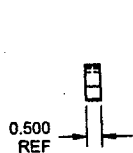
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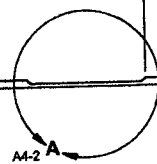
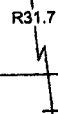
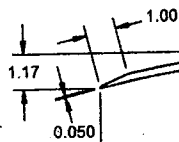
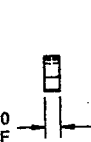
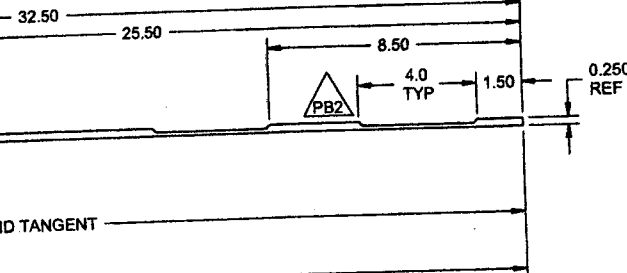
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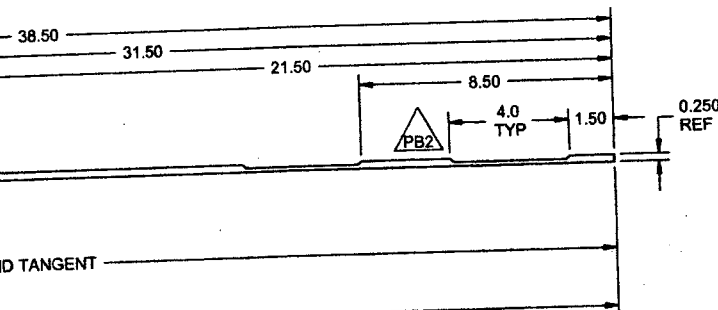
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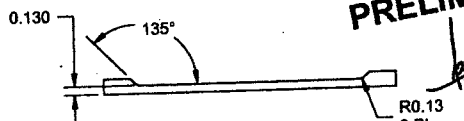
D3806-1 BAR



D3806-3 BAR



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs



DETAIL A
TYP, SCALE 2X

PRELIMINARY ISSUE

11.09.28

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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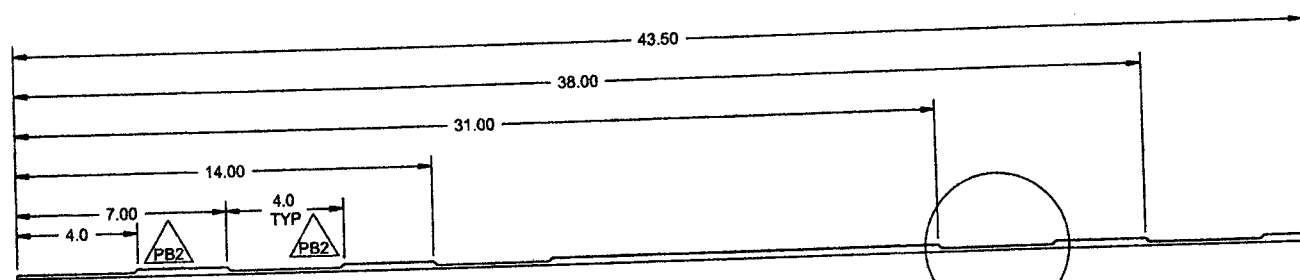
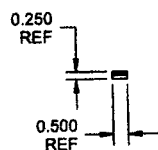
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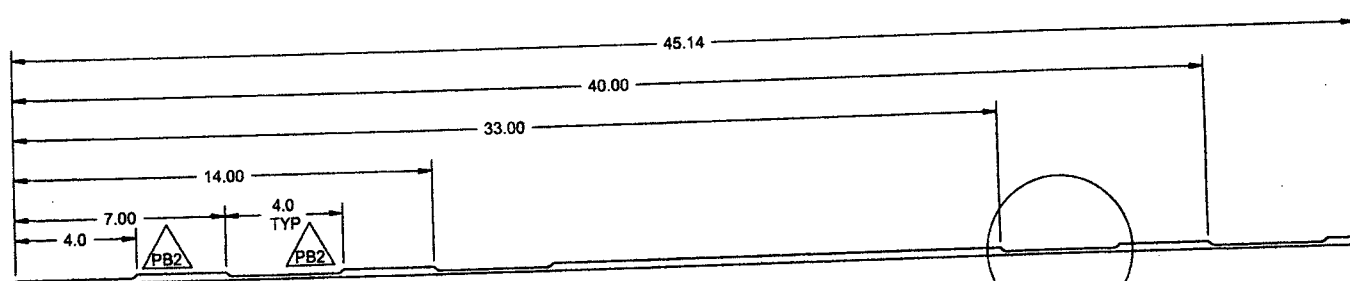
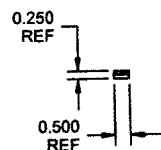
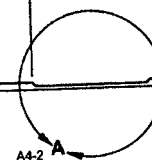
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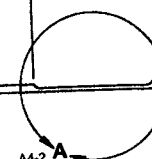
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D3806-5 BAR



D3806-7 BAR

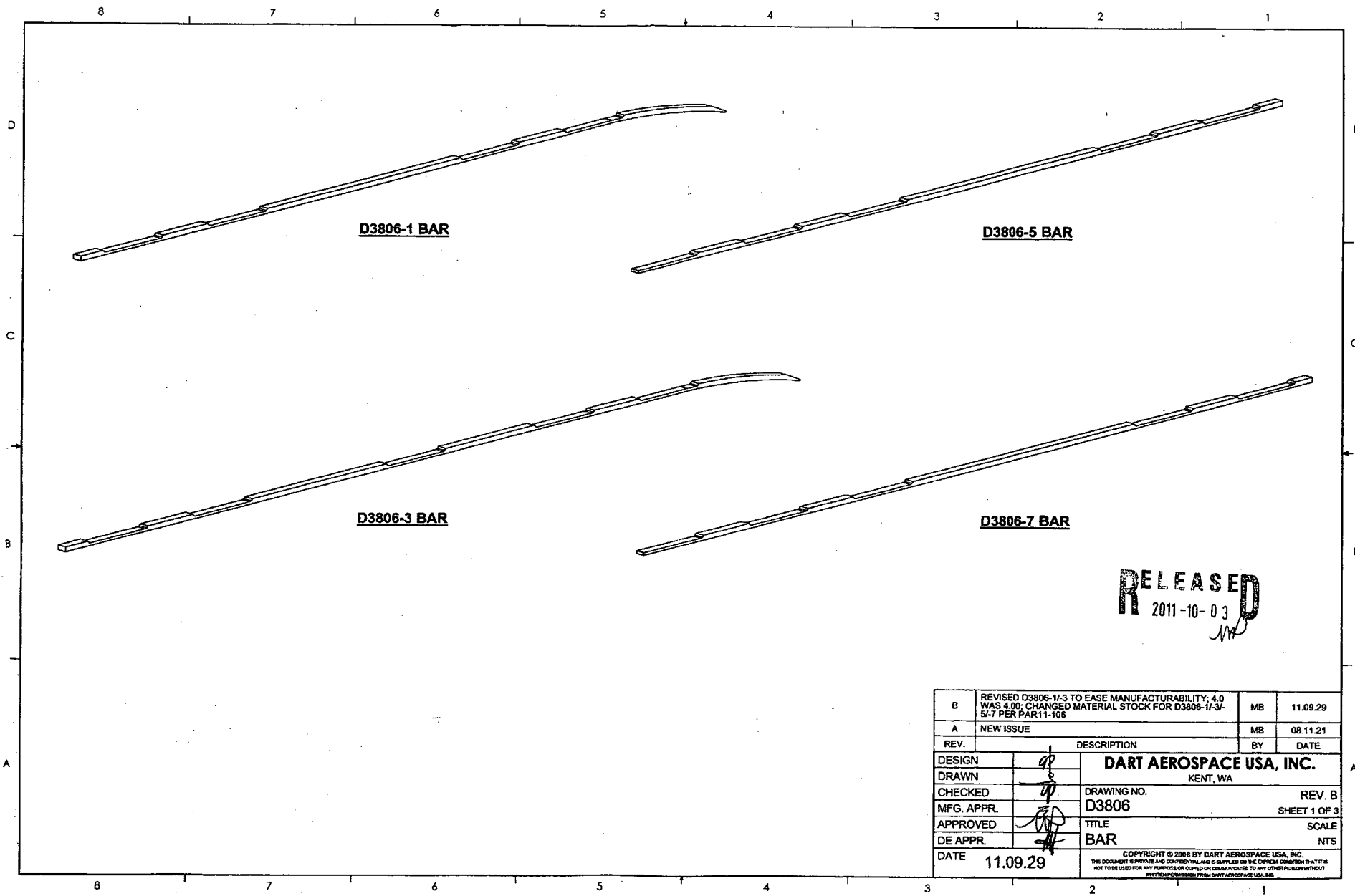


- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-5 = 1.22 lbs
D3806-7 = 1.28 lbs

PRELIMINARY ISSUE

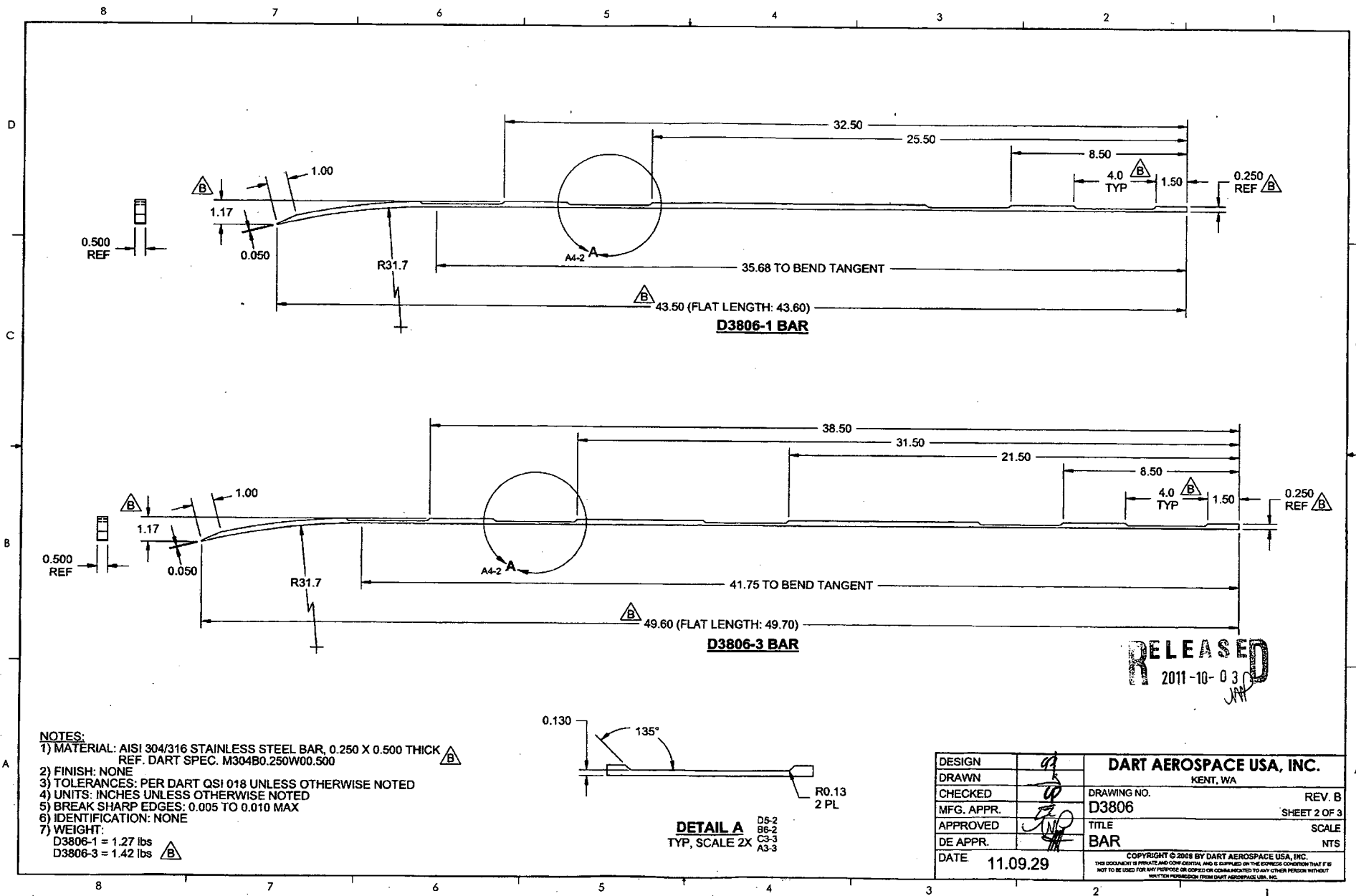
11.09.28

DESIGN	97	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. PB2
MFG. APPR.		D3806	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BAR	NTS
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RELEASED
2011-10-03
W

B	REVISED D3806-1/3 TO EASE MANUFACTURABILITY; 4.0 WAS 4.00; CHANGED MATERIAL STOCK FOR D3806-1/3/5/7 PER PAR11-108	MB	11.09.29
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>dp</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>dp</i>	KENT, WA	
CHECKED	<i>dp</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>dp</i>	D3806	SHEET 1 OF 3
APPROVED	<i>dp</i>	TITLE	SCALE
DE APPR.	<i>dp</i>	BAR	NTS
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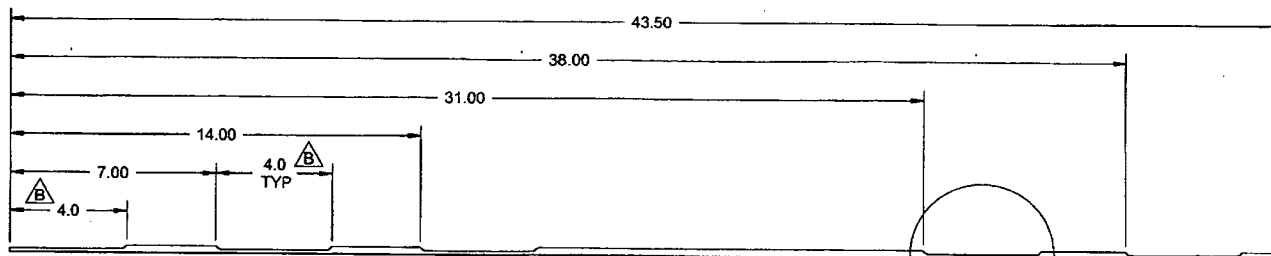
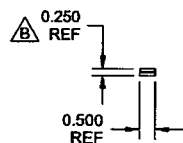
RELEASED
2011-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
REF. DART SPEC. M304B0.250W00.500
 - 2) FINISH: NONE
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 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT:
D3806-1 = 1.27 lbs
D3806-3 = 1.42 lbs

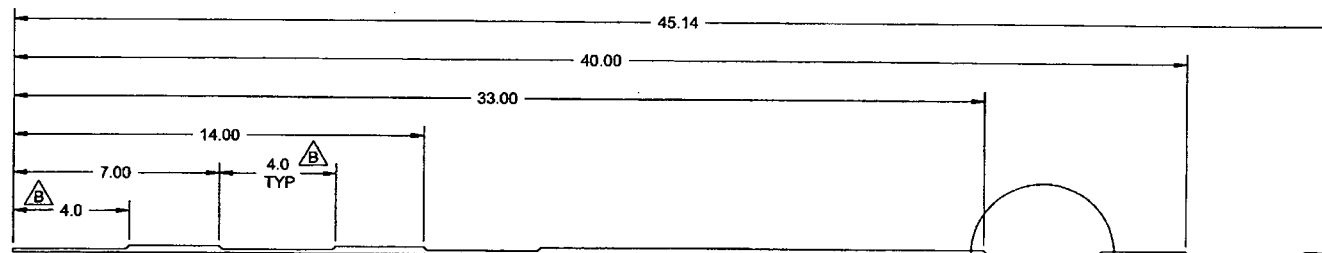
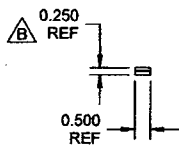
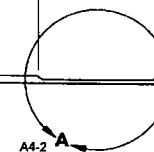
DETAIL A
TYP, SCALE 2X

DESIGN	91	DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3806	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BAR	NTS
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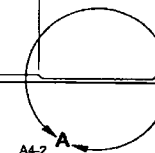
8 7 6 5 4 3 2 1



D3806-5 BAR



D3806-7 BAR



RELEASED
2011-10-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK
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DESIGN		DART AEROSPACE USA, INC.
DRAWN	<i>gpl</i>	KENT, WA
CHECKED	<i>gpl</i>	DRAWING NO. D3806
MFG. APPR.	<i>gpl</i>	REV. B
APPROVED	<i>gpl</i>	SHEET 3 OF 3
DE APPR.	<i>gpl</i>	TITLE BAR
DATE	11.09.29	SCALE NTS

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8 7 6 5 4 3 2 1